3M

# Fiber Optic Connector Crimp Tool

## Instructions

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The universal 3M brand Fiber Optic Connector Crimp Tool is designed to be used with all 3M field-mountable connectors. The package contains three sets of crimping dies. Each set of dies is designed for different connectors and their marking and application are shown in the following table.

| Die Marking | Cavity Marking | Application |
|---|---|---|
| BC/ST | .151<br>.178<br>.213 | ST* (BAYONET), FC-1, BICONIC<br>TECS (SMA) 200/230<br>PROTECTIVE COVER-8500 SPLICE |
| SC | | SC and FC-3 |
| | .120<br>.137<br>.190 | 2.4mm CABLE CRIMP RING<br>3.0mm CABLE CRIMP RING<br>KEVLAR CRIMP AREA |
| PPST | | ST ( PUSH PULL) |
| | .120<br>.137<br>.226 | 2.4mm CABLE CRIMP RING<br>3.0mm CABLE CRIMP RING<br>KEVLAR CRIMP AREA |

## Installing the Dies in the Base Tool

1. Select the appropriate set of dies as identified in the table above.

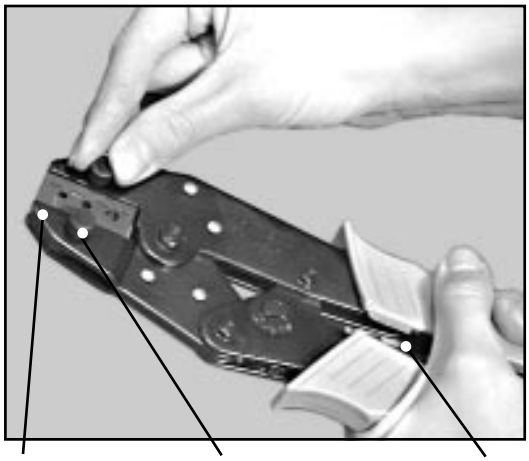
2. Squeeze and release the handles of the crimp tool to open the jaws.

3. Insert the dies into the jaws with the deep half of the round dies into the movable jaw. Match the shallow half with corresponding cavities before inserting.

4. Retain the dies **loosely** with the thumb screws.

5. Close the jaws completely to exactly align the dies. Then secure them in place by tightening the thumb screws.

6. Follow mounting procedures outlined in the appropriate connector instruction manual. See listing at right.




| CONNECTOR STYLE | INSTRUCTION MANUAL NUMBER |
|---|---|
| BICONIC** | 78-6900-1917-5 |
| SC/FC-3 | 34-7033-9144-0 |
| ST* (BAYONET) and FC-1 | 78-6900-1806-0 |
| ST* (PUSH PULL) EPOXY ADHESIVE | 78-8073-7530-4 |
| ST* (PUSH PULL) HOT MELT ADHESIVE | 78-8073-7529-6 |
| ST* (BAYONET) HOT MELT ADHESIVE | 80-6106-2571-9 |
| TECS (SMA) | (Crimp Tool Not Required) 34-7031-4262-9 |

***** To prevent deformation of the Biconic housing, insert the connector from the non-recessed side of the die.***

***Note: The crimp rings for the ST Push Pull Connector have been improved over the ones used in the manuals listed above. To obtain a new die to fit previous ST Push Pull crimp tools, please call customer service.***

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